

DUPPLICATE



Page 1

Work Order ID 48667B

July 8, 2009 8:35:10 AM

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-08 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2512	Rev E
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100



Large Fab

0.00

CD 09-07-08

Large Fab

Memo

0.00

SAD 09-07-07

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512-2-Cut (4) D2236 From
D3166-3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as
required

SS 09/07/08

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

PD 09-07-08

QC

Memo

0.00

Quality Control

Work Order ID 48667B



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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat 2- OVEN TEMPERATURE:

COAT: START TIME: 400pm FINISH TIME: 2:00pm

COAT: START TIME: 2:30pm

2ND OVEN TEM

pressure wash off
11/12/48/11/11/472

08-07-08

140



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: m11013 wing walk

Batch: m1109107 Black spray paint

und 09/07/09

Work Order ID 48667B



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July 8, 2009 8:35:10 AM

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Item Name: Basket Lid 205/350

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150



QC3- Inspect Part Finish

QC

Quality Control

160



Identify as per dwg & Stock Location:

Packaging

Packaging

Memo

PPR
48667Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
Code

Qty

Accept
Reject
Qty

Qty

Reject
Number

Stamp

170



QC21- Final Inspection - Work Order Release

QC

Quality Control

Memo

0.00

0.00

09/03/13 HJ

MF 09-07-10

⇒ 50902109

9/7/10 DS

Picklist Print

July 8, 2009 8:35:10 AM

Page 1

Work Order ID: 48667B



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 07/15/2009

Required Date: 08/03/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC		Manufactured	No			100	Each	12.0000	2.0000			

Basket Hinge

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

12

48230

12

D2327-1RevD

Manufactured No

100

Each

20.0000

2.0000

2x

SY 09/07/08

Spacer Bushing

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

20

46325

20

D2581RevA1

Manufactured No

100

Each

35.0000

2.0000

2x

SY 09/07/08

Mounting Bracket

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

35

46086

2

48428

33

D3166-3RevA1

Manufactured No

100

Each

0.0000

1.0000

2x

SY 09/07/08

Basket Hoop

B48429

1x

SY 09/07/08

Picklist Print

Page 2

July 8, 2009 8:35:10 AM

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Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 07/15/2009

Required Date: 08/03/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	868.5700	18.0000			

Expanded Metal Flat SS

Warehouse

Location

Main Warehouse

MAT	868.57	
108152	90	
110134	6.7	
110292	14.4	
110629	14.41	
110861	21.18	
110992	0.58	
111444	17.79	
111630	35.15	
111956	46.36	
112147	622	

Loc Qty

Loc Code

→ 18.00 SAD 09-07-06

M304TS0.750W.065

Purchased

No

100

f

463.0861 45.8741

304 SQ Tube .75x.75x.065W

Warehouse

Location

Main Warehouse

MAT	463.0861	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	25.14	
112051	416.2961	

Loc Qty

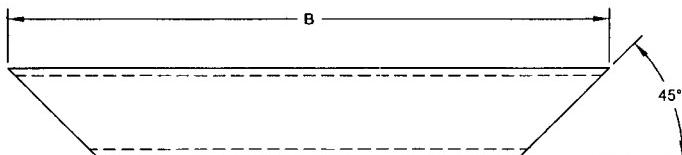
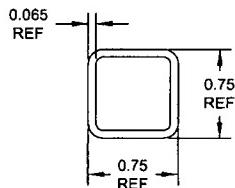
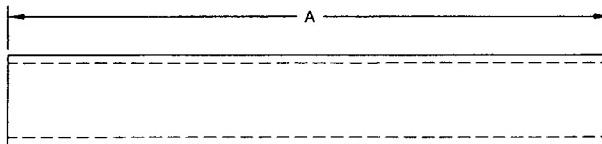
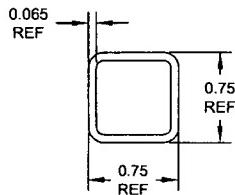
Loc Code

→ 45.8741 SAD 09-07-06

8 7 6 5 4 3 2 1

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

48667B

RELEASED
08.06.17

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	SW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. E	
MFG. APPR.		DRAWING NO.	
APPROVED		D2512	SHEET 1 OF 4
DE APPR.		TITLE	SCALE
		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8

7

6

5

4

3

2

1

A

